

# Work Order ID 97760

February-21-13 12:43:02 PM

**\*97760\***

Page 1

Item ID: D3705-041 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Instrument Panel Assembly  
 Start Date: 2/21/13 Start Qty: 2.00 **\*2\*** Cust Item ID:  
 Required Date: 3/08/13 Req'd Qty: 2.00 **\*2\*** Customer:  
 Reference:

Approvals: Process Plan: ML5 Date: 13-02-21 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_  
 Run Start **\*NR1\***  
 Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D3705	E	<i>JB</i>	100	0.00					
<b>*100*</b>	Small Fab			0.00					
Small Fab	Memo			0.00					
Small Fab	1- Assemble parts as per dwg D3705								
110	QC5- Inspect part completeness to step on W/O			0.00					
<b>*110*</b>				0.00					
QC	Memo			0.00					
Quality Control									
120	Identify as per dwg & Stock Location: _____			0.00					
<b>*120*</b>				0.00					
Packaging	Memo			0.00					
Packaging									

*DAS 16 13/07/13*

*(+2)*

*43/1/13 (2)*

*FF 13-07-13*

NCR: Yes / No

## WORK ORDER NON-CONFORMANCE / UPDATE

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  <div style="display: flex; justify-content: space-around;"> <div>Rework <input type="checkbox"/></div> <div>Skid-tube <input type="checkbox"/></div> <div>Crosstube <input type="checkbox"/></div> <div>Water Jet <input type="checkbox"/></div> <div>Engineering <input type="checkbox"/></div> </div> <div style="display: flex; justify-content: space-around;"> <div>Scrap <input type="checkbox"/></div> <div>Machining <input type="checkbox"/></div> <div>Small Fab <input type="checkbox"/></div> <div>Prod. Eng. Coord. <input type="checkbox"/></div> <div>Quality <input type="checkbox"/></div> </div> <div style="display: flex; justify-content: space-around;"> <div>Use-as-is <input type="checkbox"/></div> <div>Thermoforming <input type="checkbox"/></div> <div>Finishing <input type="checkbox"/></div> <div>Rec/Store/Packaging <input type="checkbox"/></div> <div>Other <input type="checkbox"/></div> </div> <div style="display: flex; justify-content: space-around;"> <div>Work Order Update <input type="checkbox"/></div> <div>Large Fab <input type="checkbox"/></div> <div>Composite <input type="checkbox"/></div> <div>Supplier <input type="checkbox"/></div> </div>	
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Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions
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☐ Ovalized  
☐ Over/Under tolerance  
☐ Part Incorrect  
☐ Part Lost/Missing  
☐ Part Moved  
☐ Positioned Wrong  
☐ Power Loss/Surge

☐ Pressure/Forced  
☐ Temperature/Cure  
☐ Weld  
☐ Wrong Stock Pulled  
☐ Other

# Work Order ID 97760

\*97760\*

Page 2

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Item ID: D3705-041 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Instrument Panel Assembly  
 Start Date: 2/21/13 Start Qty: 2.00 \*2\* Cust Item ID:  
 Required Date: 3/08/13 Req'd Qty: 2.00 \*2\* Customer:  
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start \*NR1\*  
 QC: Date: SPC (Y/N): Date: Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC21- Final Inspection - Work Order Release	0.00							
*130*									
QC	Memo	0.00							
Quality Control									

13/7/14

ME 13-7-03

2

13-07-02

PICK KIT

NCR: Yes / No

## WORK ORDER NON-CONFORMANCE / UPDATE

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  <div style="display: flex; justify-content: space-around;"> <div>             Rework <input type="checkbox"/>              Scrap <input type="checkbox"/>              Use-as-is <input type="checkbox"/>              Work Order Update <input type="checkbox"/> </div> <div>             Skid-tube <input type="checkbox"/>              Machining <input type="checkbox"/>              Thermoforming <input type="checkbox"/>              Large Fab <input type="checkbox"/> </div> <div>             Crosstube <input type="checkbox"/>              Small Fab <input type="checkbox"/>              Finishing <input type="checkbox"/>              Composite <input type="checkbox"/> </div> <div>             Water Jet <input type="checkbox"/>              Prod. Eng. Coord. <input type="checkbox"/>              Rec/Store/Packaging <input type="checkbox"/>              Supplier <input type="checkbox"/> </div> <div>             Engineering <input type="checkbox"/>              Quality <input type="checkbox"/>              Other <input type="checkbox"/> </div> </div>	<b>AGAINST DEPARTMENT/PROCESS</b>
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Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
<div style="display: flex; flex-direction: column; gap: 2px;"> <div><input type="checkbox"/> Doc/Data</div> <div><input type="checkbox"/> Equip/Tooling</div> <div><input type="checkbox"/> Operator</div> <div><input type="checkbox"/> Material</div> <div><input type="checkbox"/> Setup</div> <div><input type="checkbox"/> Other</div> <div><input type="checkbox"/> Process</div> <div><input type="checkbox"/> Supplier</div> <div><input type="checkbox"/> Training</div> <div><input type="checkbox"/> Unapproved</div> </div>									

### FAULT CATEGORY

<b>Landing Gear</b>  <div style="display: flex; flex-direction: column; gap: 2px;"> <input type="checkbox"/> Bending           <input type="checkbox"/> Centre Not Concentric to O/S           <input type="checkbox"/> Cracks           <input type="checkbox"/> Crushed/Crimped           <input type="checkbox"/> Cuffs           <input type="checkbox"/> Heat Treat           <input type="checkbox"/> Inspection Strip in Tube           <input type="checkbox"/> Ripples in Bend           <input type="checkbox"/> Torque Waves in Extrusion           <input type="checkbox"/> Turning Sequence           <input type="checkbox"/> Wave/Twist in Tube         </div>	<b>General</b>  <div style="display: flex; flex-direction: column; gap: 2px;"> <input type="checkbox"/> Bend           <input type="checkbox"/> BOM/Route           <input type="checkbox"/> Broken/Damaged           <input type="checkbox"/> Burrs           <input type="checkbox"/> Contamination           <input type="checkbox"/> Countersink           <input type="checkbox"/> Cut Too Short           <input type="checkbox"/> Drill Holes           <input type="checkbox"/> Drawing           <input type="checkbox"/> Finish           <input type="checkbox"/> Folio         </div>	<div style="display: flex; flex-direction: column; gap: 2px;"> <input type="checkbox"/> Grain           <input type="checkbox"/> Hardware           <input type="checkbox"/> Inspection Incomplete           <input type="checkbox"/> Instructions Incomplete/Unclear           <input type="checkbox"/> Maintenance           <input type="checkbox"/> Mislabeled           <input type="checkbox"/> Misread           <input type="checkbox"/> Offset           <input type="checkbox"/> Out of Calibration           <input type="checkbox"/> Out of Sequence           <input type="checkbox"/> Outside Dimensions         </div>	<div style="display: flex; flex-direction: column; gap: 2px;"> <input type="checkbox"/> Ovalized           <input type="checkbox"/> Over/Under tolerance           <input type="checkbox"/> Part Incorrect           <input type="checkbox"/> Part Lost/Missing           <input type="checkbox"/> Part Moved           <input type="checkbox"/> Positioned Wrong           <input type="checkbox"/> Power Loss/Surge         </div>	<div style="display: flex; flex-direction: column; gap: 2px;"> <input type="checkbox"/> Pressure/Forced           <input type="checkbox"/> Temperature/Cure           <input type="checkbox"/> Weld           <input type="checkbox"/> Wrong Stock Pulled           <input type="checkbox"/> Other         </div>
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Page 1

Work Order ID: 97760  
Parent Item: D3705-041  
Parent Item Name: Instrument Panel Assembly

Start Date: 2/21/13

Required Date: 3/08/13

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A new issue 08-05-30 DD verified by:ec  
IPP rev:B 09-01-09 rev.C as per dwg DD verified by:ec  
IPP Rev:C 09-01-15 rivet chg DD verified by:EC  
NCR10-017 DD verified by:EC  
IPP Rev:E as per dwg RevD DD 10.04.27 verified by:EC  
DD VERF:JLM  
IPP rev:D 10.04.21 washer chg per  
IPP REV:F 12.12.03 REV PE1  
IPP REV:G 13.01.15 AS PER DWG REV.E DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3335-1 Short Spring		Manufactured	No			100	Each	2.0000	1	2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		2		B103839		2			
				96050		2							
D3705-043 Instrument Panel Weldment		Manufactured	No			100	Each	2.0000	1	2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				st200		2							
				96054		2							
D3705-5 Access Panel		Manufactured	No			100	Each	7.0000	1	2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST063		7							
				54825		3							
				90127		2							
				95132		2							
D3706-041 Lock Bracket Assembly		Manufactured	No			100	Each	0.0000	1	2			
								B96056					
D3706-5 Pin		Manufactured	No			100	Each	13.0000	1	2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST063		13							
				56914		3							
				96235		10							

Sh 13/07/02

2

97051 ✓

20

90127

Sh 13/07/02

20

13-07-02

175694  
1796235

NCR: Yes / No

## WORK ORDER NON-CONFORMANCE / UPDATE

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data <input type="checkbox"/>									
Equip/Tooling <input type="checkbox"/>									
Operator <input type="checkbox"/>									
Material <input type="checkbox"/>									
Setup <input type="checkbox"/>									
Other <input type="checkbox"/>									
Process <input type="checkbox"/>									
Supplier <input type="checkbox"/>									
Training <input type="checkbox"/>									
Unapproved <input type="checkbox"/>									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions
		<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other

# Picklist Print

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Work Order ID: 97760

Parent Item: D3705-041

Parent Item Name: Instrument Panel Assembly

Start Date: 2/21/13

Required Date: 3/08/13

Start Qty: 2.00

Required Qty: 2.00

D3707-3 Manufactured No

100 Each 11.0000 2 4

Mounting Lug

Location Loc Qty Loc Code

ST063 11  
94971 6  
96127 5

34-94971  
14-96127

AN3-3A Purchased No

100 Each 439.0000 2 4

Bolt

Location Loc Qty Loc Code

ST350 439  
123831 139  
124221 200  
124552 100

125709

AN526C1032R6 Purchased No

100 Each 679.0000 4 8

Screw

Location Loc Qty Loc Code

ST346 679  
1892 679

1892

AN960JD516 Washer Purchased No

NAS1149D0563J

100 Each 2.0000 1 1

Location Loc Qty Loc Code

ST504 2  
1069059 2

125802

CRI122-3-02.5 RIVET Purchased No

100 Each 43.0000 28 56

Location Loc Qty Loc Code

ST327 43  
122845 43

124762

56

MS171498 Spring Pin Purchased No

100 Each 38.0000 1 2

Location Loc Qty Loc Code

ST331 38  
108521 38

108521

FF13-07-3

13-07-02

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NCR: Yes / No

## WORK ORDER NON-CONFORMANCE / UPDATE

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width: 100%; border: none;"> <tr> <td style="width: 33%;">Skid-tube <input type="checkbox"/></td> <td style="width: 33%;">Crosstube <input type="checkbox"/></td> <td style="width: 33%;">Water Jet <input type="checkbox"/></td> <td style="width: 33%;">Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
<div style="display: flex; flex-direction: column; gap: 2px;"> <div><input type="checkbox"/> Doc/Data</div> <div><input type="checkbox"/> Equip/Tooling</div> <div><input type="checkbox"/> Operator</div> <div><input type="checkbox"/> Material</div> <div><input type="checkbox"/> Setup</div> <div><input type="checkbox"/> Other</div> <div><input type="checkbox"/> Process</div> <div><input type="checkbox"/> Supplier</div> <div><input type="checkbox"/> Training</div> <div><input type="checkbox"/> Unapproved</div> </div>									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions
<div style="display: flex; flex-direction: column; gap: 2px;"> <div><input type="checkbox"/> Ovalized</div> <div><input type="checkbox"/> Over/Under tolerance</div> <div><input type="checkbox"/> Part Incorrect</div> <div><input type="checkbox"/> Part Lost/Missing</div> <div><input type="checkbox"/> Part Moved</div> <div><input type="checkbox"/> Positioned Wrong</div> <div><input type="checkbox"/> Power Loss/Surge</div> </div>		
<div style="display: flex; flex-direction: column; gap: 2px;"> <div><input type="checkbox"/> Pressure/Forced</div> <div><input type="checkbox"/> Temperature/Cure</div> <div><input type="checkbox"/> Weld</div> <div><input type="checkbox"/> Wrong Stock Pulled</div> <div><input type="checkbox"/> Other</div> </div>		



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Work Order ID: 97760

Parent Item: D3705-041

Parent Item Name: Instrument Panel Assembly

Start Date: 2/21/13

Required Date: 3/08/13

Start Qty: 2.00

Required Qty: 2.00

MS21075L3	Purchased	No	100	Each	432.0000	14	28	- JB
Nutplate								
		<u>Location</u>	<u>Loc Qty</u>		<u>Loc Code</u>			
		GA	400					
		124670	400			124670		
		ST318	32					
		123832	17					
		124551	15					
MS24693-C272	Purchased	No	100	Each	1,216.0000	4	8	- JB
Screw								
		<u>Location</u>	<u>Loc Qty</u>		<u>Loc Code</u>			
		ST300	1216					
		17137	467					
		17831	519					
		9370	230			9370		
NAS1149D0332J	Purchased	No	100	Each	929.0000	2	4	125807 JB 13-07-02
Washer								
		<u>Location</u>	<u>Loc Qty</u>		<u>Loc Code</u>			
		FP001	44					
		122973	44					
		ST294	885					
		122973	885					

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NCR: Yes / No

**WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

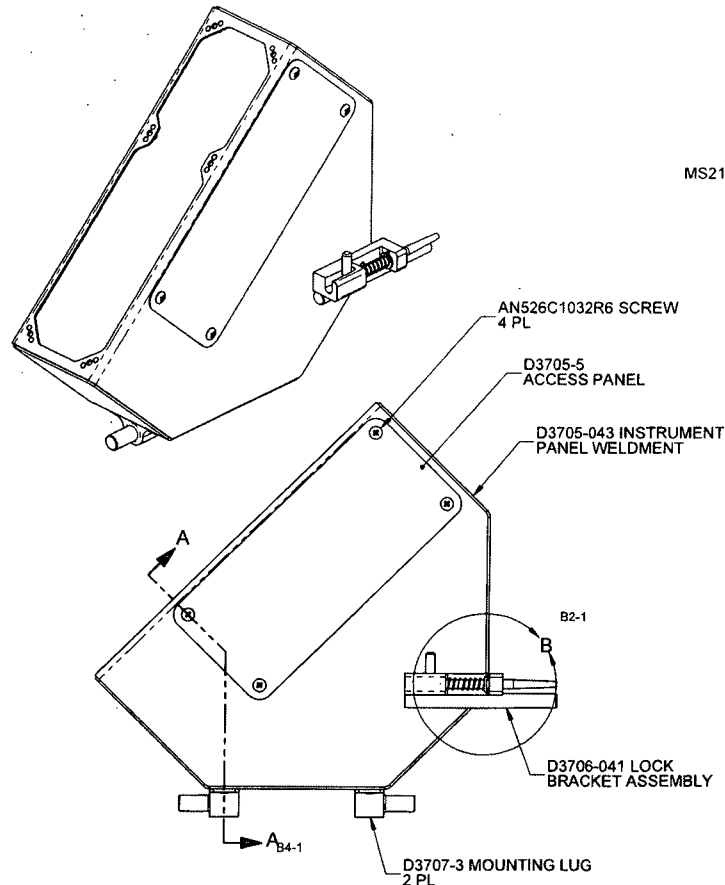
QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

**FAULT CATEGORY**

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not*Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled  <input type="checkbox"/> Other
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### D3705-041 INSTRUMENT PANEL ASS'Y

#### D3705-041 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N AND B/N PER DART QSI 044 6.1 (PERMANENT INK MARKER)
- 7) WEIGHT: 3.20 lbs

MS21075L3 NUTPLATE  
REF

AN526C1032R6 SCREW  
4 PL

D3705-5  
ACCESS PANEL

D3705-043 INSTRUMENT  
PANEL WELDMENT

B2-1

D3706-041 LOCK  
BRACKET ASSEMBLY

D3707-3 MOUNTING LUG  
2 PL

AN3-3A BOLT  
NAS1149D0332J WASHER  
2 PL

SECTION A-A  
SCALE 2X

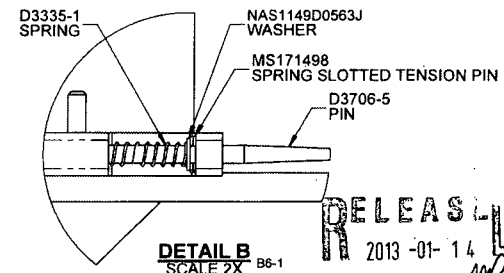
SECTION G-G  
SCALE 2X

MS21075L3 NUTPLATE, 1X  
CR1122-3-02.5 RIVET, 2X  
14 PL

MS24693-C272 SCREW  
4 PL

D3707-3 MOUNTING LUG  
REF

ITEM	QTY	P/N	DESCRIPTION
	X	D3705-041	INSTRUMENT PANEL ASS'Y
1	1	D3335-1	SPRING
2	1	D3705-043	INSTRUMENT PANEL WELDMENT
3	1	D3705-5	ACCESS PANEL
4	1	D3706-041	LOCK BRACKET ASSEMBLY
5	1	D3706-5	PIN
6	2	D3707-3	MOUNTING LUG
7	2	AN3-3A	BOLT
8	4	AN526C1032R6	SCREW
9	1	NAS1149D0563J	WASHER (OR AN960JD516)
10	28	CR1122-3-02.5	RIVET
11	1	MS171498	SPRING SLOTTED TENSION PIN
12	14	MS21075L3	NUT PLATE
13	4	MS24693C272	SCREW
14	2	NAS1149D0332J	WASHER (OR AN960JD10L)



E	REVISED D3705-1/3 (NOW 0.75 TALLER - AFFECTS -1F-3F); D3706-1/3 NOW D3706-041 AND BOLTED; ADD AN3-3A BOLT, NAS1149D0332J WASHER, D3706-041; 9.88 WAS 9.13 (ZN D1-3, B3-3, C7-4); 6.000 WAS 7.150 (ZN C4-5); 3.20 lbs WAS 3.00 lbs. REASON: CIR12-4/PAR12-185.	MB	12.11.30
D	ITEM 14 WAS AN960JD416 (ZN D3-1 AND C1-1). REASON: NCR#10-017.	MB	10.04.15
C	ADDED D3705-7/8-11 (SHEET 6); REMOVED MS35589-156 GROMMET; 9.31 AND 12.66 WERE 9.36 AND 12.61 (ZN B6-3); Ø1.90 WAS 1.50 (ZN D5-4); ADDED Ø0.204 HOLE (ZN D5-4); CR1122-3-02.5 WAS MS20426AD3-3. REASON: COMPLETED DESIGN OF FACE PLATES REQUIRED TO MOUNT INSTRUMENTS.	MB	08.11.20
B	ADDED MS35488-156. QTY 14 MS21075L3 WAS QTY 8; QTY 28 MS20426AD3-3 WAS QTY 16; MS171498 WAS TP-2; AN526C1032R6 WAS MS27039-1-09 & AN960JD10L (ZN D3-1); REDESIGNED D3705-1F FLAT PATTERN (ZN B6-3). REASON: GIVE MORE FLEXIBILITY TO CUSTOMER IN TERMS OF INSTRUMENT ARRANGEMENT	MB	08.08.07
A	NEW ISSUE	MB	08.05.26
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	12.11.30		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3705** REV. E  
SHEET 1 OF 6  
TITLE **INSTRUMENT PANEL ASS'Y** SCALE NTS

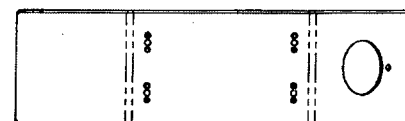
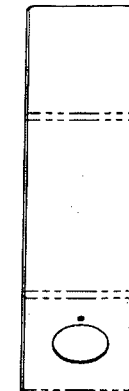
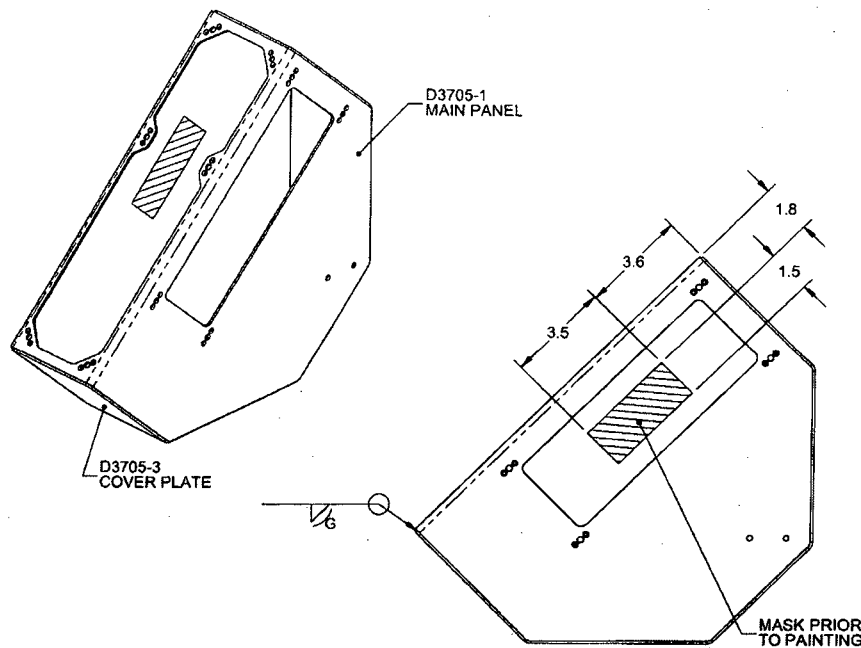
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UNCONTROLLED COPY  
SUBJECT TO CHANGE  
WHILE IN STOCK  
WORK ORDER  
NO. 93760 MWS  
13-02-21



97760

ITEM	-043 QTY.	P/N	DESCRIPTION
1	X	D3705-043	INSTRUMENT PANEL WELDMENT
3	1	D3705-1	MAIN PANEL
4	1	D3705-3	COVER PLATE



**D3705-043 INSTRUMENT PANEL WELDMENT**

**D3705-043 NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT BLACK (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 3.20 lbs
- 8) WELDING: PER DART QSI 004

**RELEASED**  
2013-01-14

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. <b>D3705</b>	REV. E
MFG. APPR.		TITLE	SHEET 2 OF 8
APPROVED		<b>INSTRUMENT PANEL ASSY</b>	SCALE
DE APPR.			NTS
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**D3705-1F MAIN PANEL**

Grain Direction: 45° TYP, REF

Dimensions (inches):

- Top: 13.50, 13.125, 12.927, 12.50, 9.36, 9.125, 8.94, 8.625, 8.31, 7.89, 4.375, 4.00, 1.18, 0.573, 0.375, 0.00
- Bottom: 0.00, 4.375, 10.06, 10.310, 10.86, 12.61, 13.164, 13.41, 14.348, 14.60, 17.60, 17.848, 19.098, 23.47
- Right: 10.49, 12.99, 21.858, 22.741, 12.750, 8.733, 7.849, 3.750, 4.00, 3.350, 2 PL, REF
- Left: 0.080 REF

**DETAIL C**  
SCALE 4X  
10 PL

**DETAIL D**  
SCALE 4X  
10 PL

**D3705-1F MAIN PANEL**  
MAKE FROM D3705-1F

**RELEASED**  
2013-01-14

**D3705-1F NOTES:**

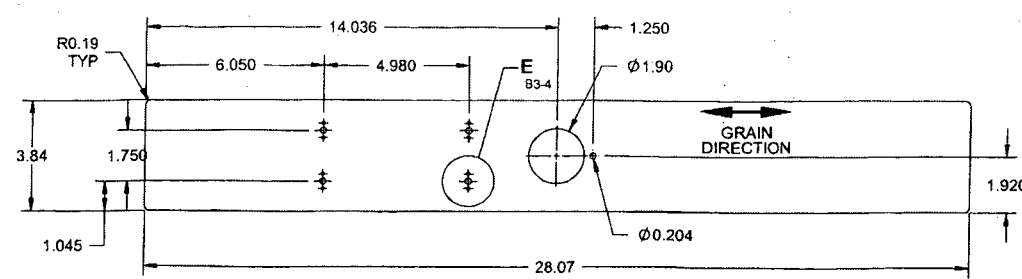
- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF. DART SPEC. M6061T6S.080)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.65 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3705	SHEET 3 OF 6
APPROVED		TITLE	SCALE
DE APPR.		INSTRUMENT PANEL ASSY	NTS
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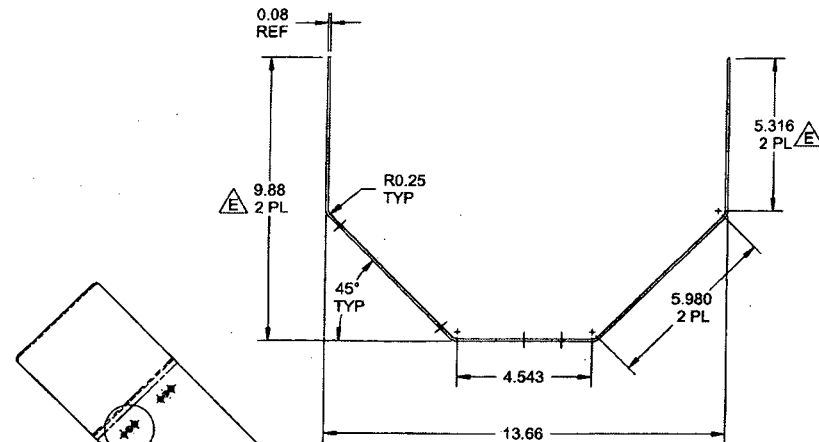




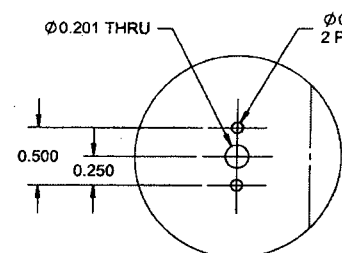
97760



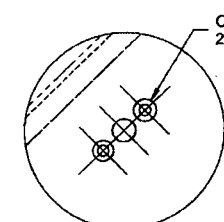
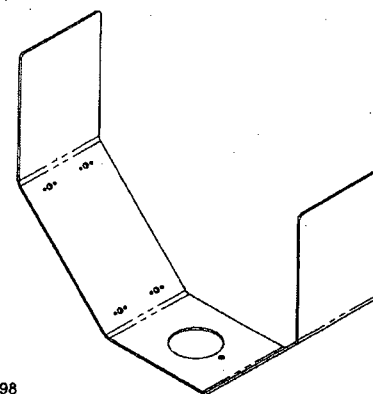
**D3705-3F COVER PLATE FLAT PATTERN**



**D3705-3 COVER PLATE  
(MAKE FROM D3705-3F)**



**DETAIL E  
SCALE 4X  
4 PL**



**DETAIL F  
SCALE 4X  
4 PL**

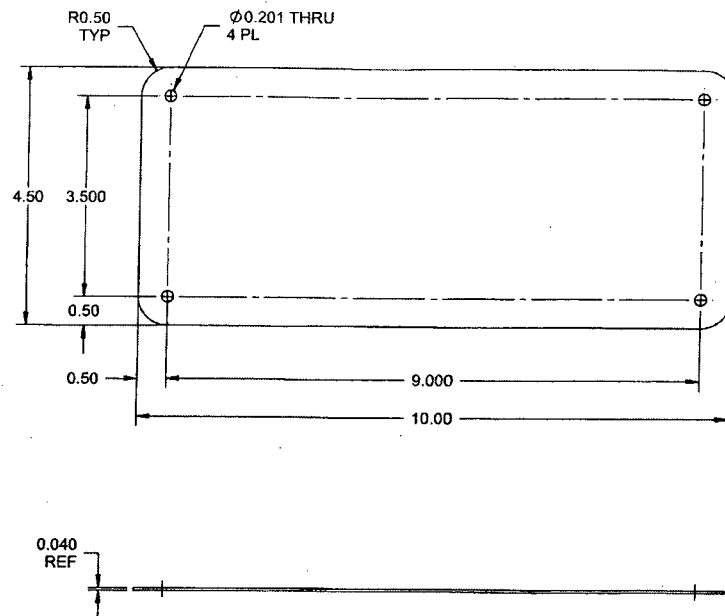
**RELEASE**  
2013-01-14

- D3705-3/-3F NOTES:**
- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
(REF. DART SPEC. M6061T6S.080)
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.82 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. <b>D3705</b>	REV. E
MFG. APPR.		TITLE <b>INSTRUMENT PANEL ASSY</b>	SHEET 4 OF 6
APPROVED		SCALE	NTS
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97760



**D3705-5 ACCESS PANEL**

RELEASED  
2013-01-14

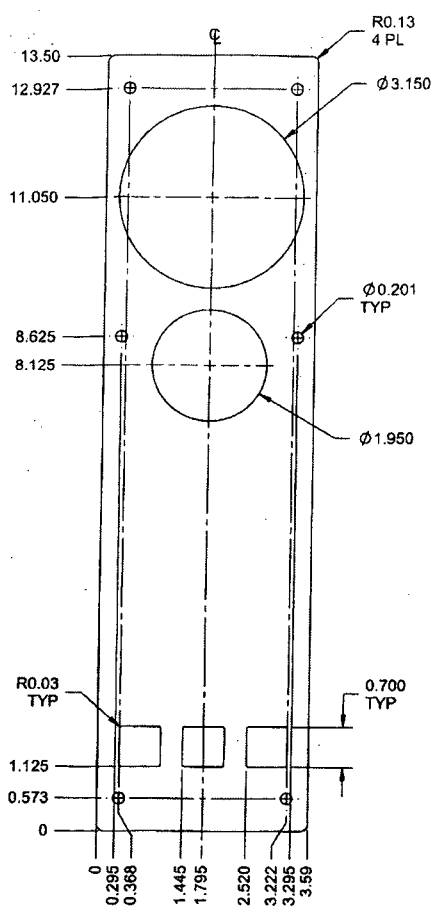
**D3705-5 NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.040 THICK  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
(REF. DART SPEC. M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT BLACK (4.3.5.7) PER DART QSI 005 4.3
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N AND B/N PER DART QSI 044 6.1 (PERMANENT INK MARKER)
- 8) WEIGHT: 0.17 lbs

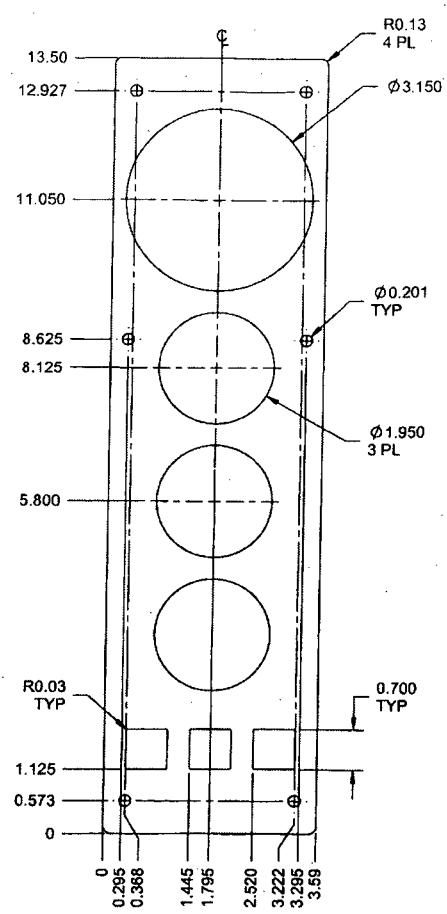
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CHECKED		DRAWING NO.	REV. E
MFG. APPR.		<b>D3705</b>	SHEET 5 OF 6
APPROVED		TITLE	SCALE
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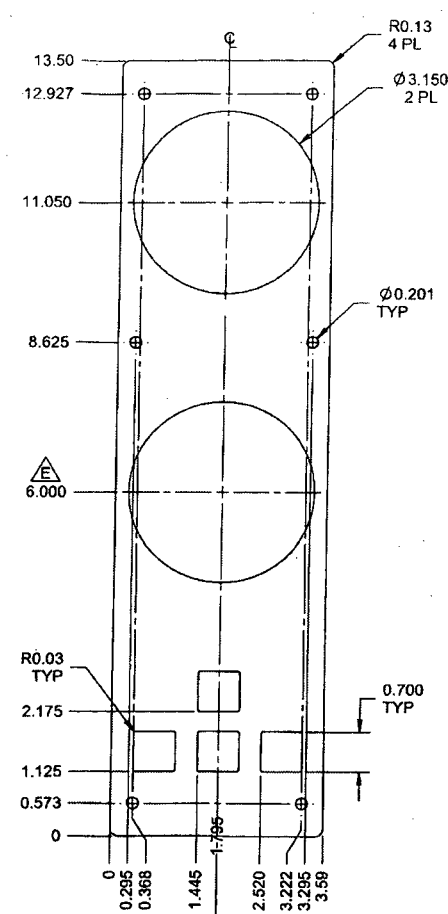
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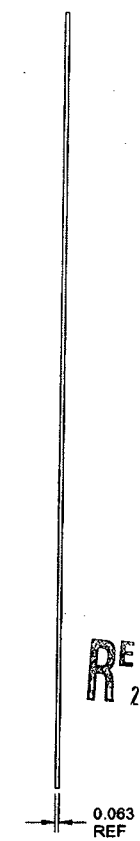
**D3705-7 FACE PLATE**



**D3705-9 FACE PLATE**



**D3705-11 FACE PLATE**



**SIDE VIEW  
TYP**

**D3705-7/-9/-11 NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.063 THICK  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
(REF. DART SPEC. M8061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT BLACK (4.3.5.7) PER DART QSI 005 4.3
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N AND B/N PER DART QSI 044 6.1 (PERMANENT INK MARKER)
- 8) WEIGHT: D3705-7 = 0.22 lbs; D3705-9 = 0.18 lbs; D3705-11 = 0.19 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
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MFG. APPR.		<b>D3705</b>	SHEET 6 OF 6
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